

Date: Wednesday, 28/11/2007 2:43:29 PM
User: Linda Lacelle

Process Sheet

SPRINT
SD 07/12/26

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 33999 - 1
Estimate Number : 12568
P.O. Number : N/A
This Issue : 28/11/2007 S.O. No. : N/A
Prsht Rev. : NC
First Issue : 16/08/2007 Type : LARGE FAB ASSY
Previous Run : 33577
Written By :
Checked & Approved By :
Comment : Est. Rev: A New Issue 06-11-08 JLM

Drawing Name : HELI-ACCESS STEP RH (FOLDING)
Part Number : D412630034
Drawing Number : IIN UNDER REVIEW
Project Number : N/A
Drawing Revision : K
Material : N/A
Due Date : 05/09/2007 Qty: 5 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & create labels per PPP D412-630-034 CHG002

5086010

2.0 D2012107 Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Clevis

Pick:

Qty	Part Number	Description
1	D2012-107	Clevis

Batch

33585, 50

3.0 D2803042 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description
1	D2803-042	Bracket Assembly RH

Batch

207016
27283
33392

4.0 D2804042 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description
1	D2804-042	Bracket Assembly RH

Batch

34018
39409 7/12/27505X

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 33999

Part Number: D412630034

Job Number:



Seq. #:	Machine Or Operation:	Description :
5.0	D2807	Gas Spring (Support Prop)
<div><div></div><div></div></div> <p>Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s) Support Prop Pick: Qty Part Number Description Batch 2 D2807 <i>041</i> Gas Spring <i>35962</i></p> <p><i>UPON INSTALL, REMOVE IDENTIFIER OF GAS SPRING</i></p>		
6.0	D2813	Washer
<div><div></div><div></div></div> <p>Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s) Washer Pick: Qty Part Number Description Batch 2 D2813 Washer <i>3277</i></p>		
7.0	D3562042	STEP ASSEMBLY, RH
<div><div></div><div></div></div> <p>Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s) Step Weldment LH Pick: Qty Part Number Description Batch 1 D3562-042 Step Weldment RH <i>335822</i></p> <p><i>SD 07/12/27 (5)</i></p>		
8.0	D33951	Bushing
<div><div></div><div></div></div> <p>Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s) Bushing Pick: Qty Part Number Description Batch 4 D3395-1 Bushing <i>33576</i></p>		
9.0	AN3C21A	BOLT
<div><div></div><div></div></div> <p>Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s) BOLT Pick: Qty Part Number Description Batch 2 AN3C21A Bolt <i>2101189</i></p> <p><i>7/12/27 (5x)</i></p>		

Process Sheet

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Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 33999

Part Number: D412630034

Job Number:



Seq. #: Machine Or Operation: Description :

10.0 AN8C16 Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description
2	AN8C16	Bolt

Batch

MIC 736

SP

11.0 AN310C8 Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description
2	AN310C8	Nut

Batch

MIC 559

SP

12.0 MS24665302 Cotter Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Cotter Pin

Pick:

Qty	Part Number	Description
2	MS24665-302	Cotter Pin (or AN380C3-4)

Batch

MIC 741

SP

13.0 NAS1515H3 Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total: 30.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
6	NAS1515H3	Washer

Batch

MIC 792

SP

14.0 NAS1515H5L WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description
4	NAS1515H5L	Washer

Batch

MIC 792

7/12/27305X

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 33999

Part Number: D412630034

Job Number:



Seq. #: Machine Or Operation: Description:

15.0 NAS1515H8 Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
4	NAS1515H8	Washer

Batch

M104711

SP

16.0 MS210433 Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description
4	MS21043-3	Nut

Batch

M105792

SP

17.0 MS24693C280 Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Screw

Pick:

Qty	Part Number	Description
2	MS24693-C280	Screw (or MS24694-C565)

Batch

M101390, 4/10/2750 (2)

18.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor

A/R LPS3 batch: ~~M104929~~ M104929

COAT exposed HARDWARE WITH LPS PROCYON.

A/R LPS PROCYON BATCH: M17045

SAG 07-12-27 (2)

19.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

D412-31 (2)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 33999

Part Number: D412630034

Job Number:



Seq. #:	Machine Or Operation:	Description :
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20.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Pick Packing Kit

21.0	D28061	Bushing
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)
Bushing

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D2806-1	Bushing	33590

AS 07/12/28

22.0	D28063	Bushing
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)
Bushing

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D2806-3	Bushing	B27286 3x

B29847 x1

AS 07/12/28

23.0	D28105	Strut
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
Strut

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	D2810-5	Strut	B32775 x1

B35829 x1

AS 07/12/28

24.0	D33961	Spacer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)
Spacer

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D3396-1	Spacer	34025

AS 07/12/28

25.0	AN4C6A	Bolt
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
			M105793

AS 07/12/28

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 33999

Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 AN4C6A Bolt

26.0 AN4C10A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	AN4C10A	Bolt	M101189

AS 07/12/28 (K2)

27.0 AN4C15A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	AN4C15A	Bolt	M103915

AS 07/12/28 (K2)

28.0 AN4C7A Eyebolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Eyebolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	AN4C7A	Eyebolt	M101711

AS 07/12/28 (K2)

29.0 AN5C15A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	AN5C15A	Bolt	M105125

AS 07/12/28 (K2)

30.0 NAS1515H4 Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total: 35.0000 Each(s)

Washer

Pick: Packing Kit

Qty	Part Number	Description	Batch
7	NAS1515H4	Washer	M105516

AS 07/12/28 (K2)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 33999

Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

NAS1515H5

Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total: 35.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number

Description

Batch

7 NAS1515H5

Washer

M165792

AS 07/12/28

(2)

32.0

MS210434

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number

Description

Batch

4 MS21043-4

Nut

106421

AS 07/12/28

(2)

33.0

MS210435

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total: 15.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number

Description

Batch

3 MS21043-5

Nut

105430

AS 07/12/28

(2)

34.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

AS 08/01/10 (2)

35.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-034

Location:

PPP Rev:

A

8/1/10 sq

(2) AS

36.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(2) AS
28.06.11

Job Completion



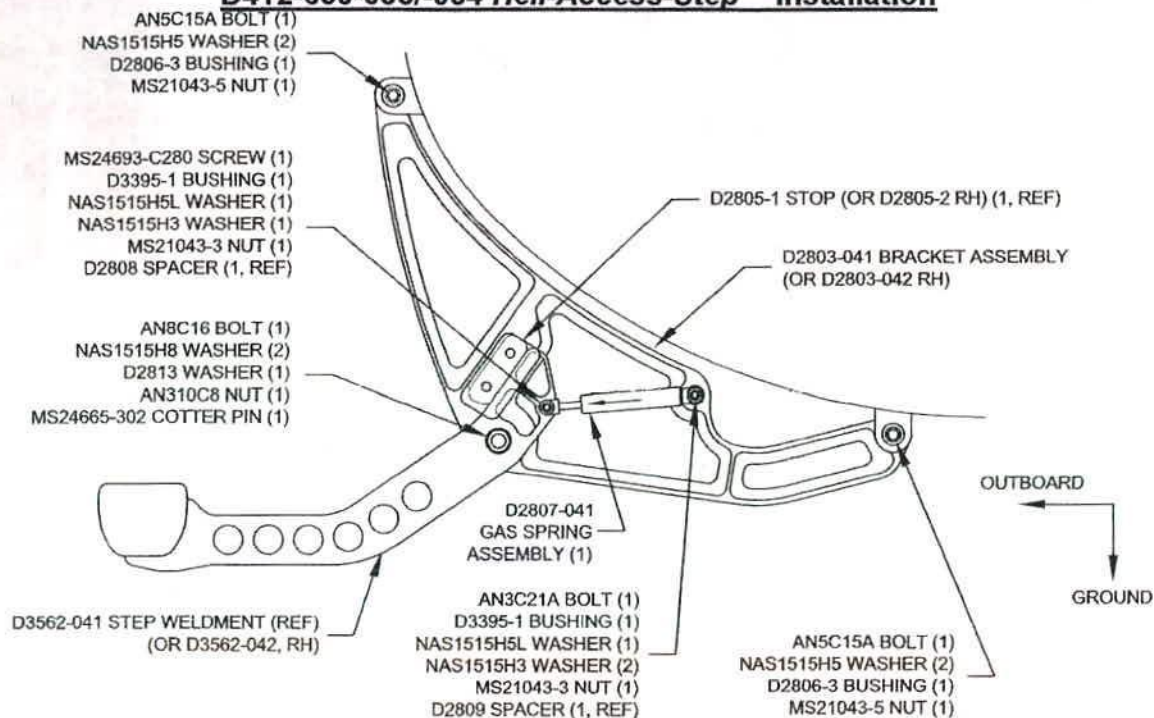
D412-630-033/-034 Heli-Access-Step™ Installation

FIGURE 14 – STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation (View rotated 90° CW)

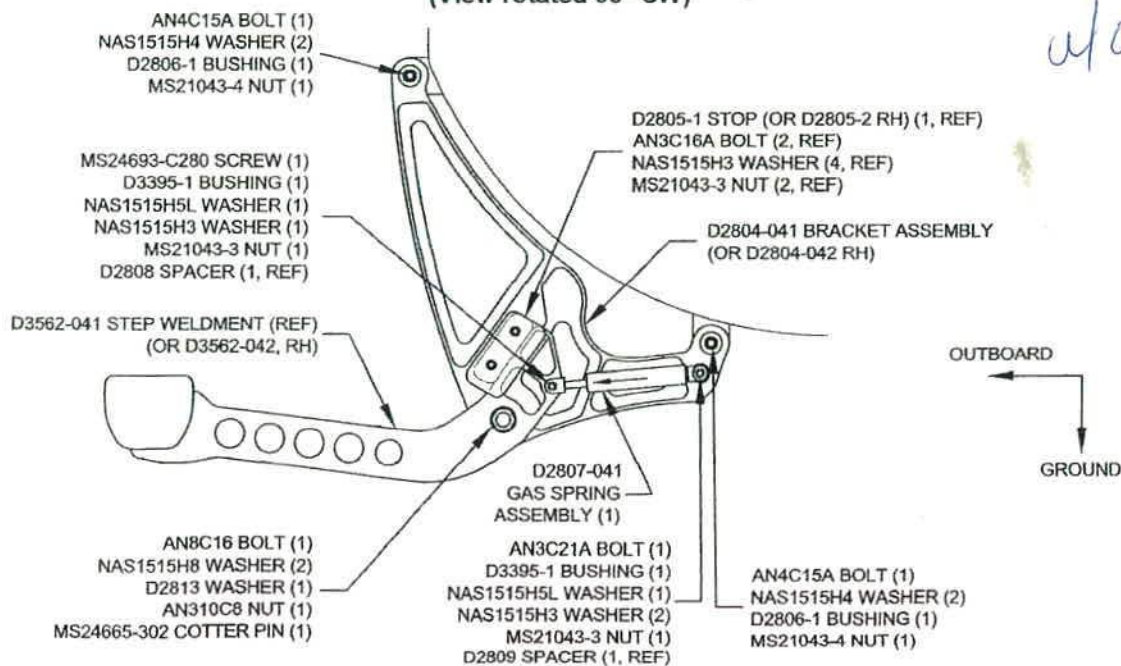


FIGURE 15 – STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation (View rotated 90° CW)

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Revision: **L**
Date: 07.09.30